

Ship July 14

Date: Thursday, 6/29/2006 3:52:31 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT WELDMENT ASS'Y
 Job Number : 27794
 Estimate Number : 10554
 P.O. Number : NIA Part Number : D34431
 This Issue : 6/29/2006 S.O. No. : NIA Drawing Number : D3443 REVB
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 27529 Material : NIA
 Due Date : 7/12/2006 Qty: 9 Um: Each
 Written By : See Comment Below
 Checked & Approved By : 06 06 29
 Comment : A 05.11.04 New issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B2500X1250 17-4 SS BAR



Comment: Qty.: 0.2100 f(s)/Unit Total: 0.8400 f(s)
 Material: 17-4 SS Bar 2.500" X 1.250"
 (M17-4-B2.500x01.250)
 Batch: M101422

J.F. 06/07/02

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 2.400" long

J.F. 06/07/02

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA587 Rev: AA & Dwg D3443 Rev: B

SA 06.07.04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.07.04


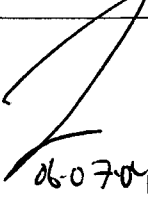
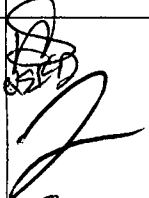
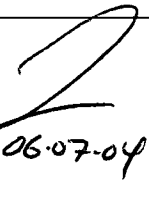

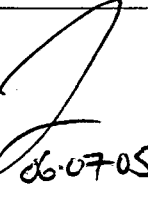
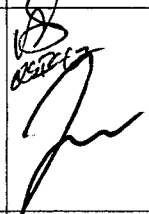
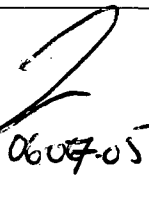
5.0 QC8 SECOND CHECK




Comment: SECOND CHECK

JL 06/07/05 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.07.04	3.0	Drill burnt: broke inside of the part. 1 part, Scrap only.		destroy: replace	SD 06.07.04	 06.07.04		 06.07.04
06.07.04	3.0	-part pulled up white machining		Scrap. <u>NO replace</u>	SD 06.07.04	 06.07.05		 06.07.05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 3:52:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 27794

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Tumble & deburr per dwg D3443

SD 060704

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

060705

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 436 L.B.

06/17/06 (9)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06107107

Job Completion



060707

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

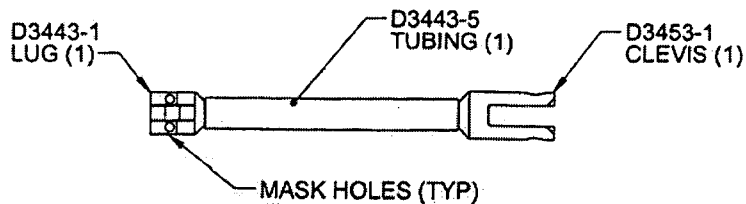
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

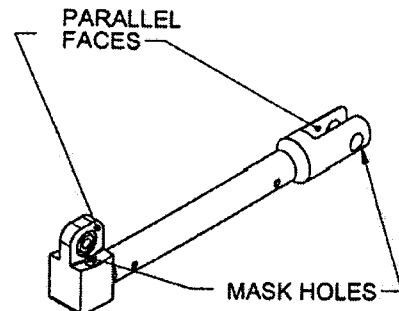
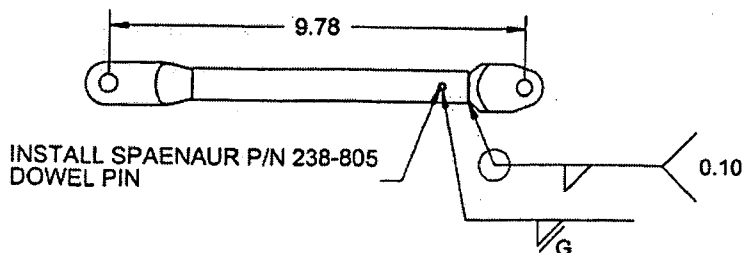
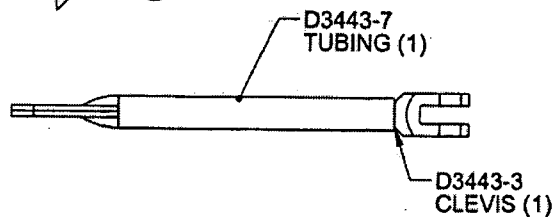
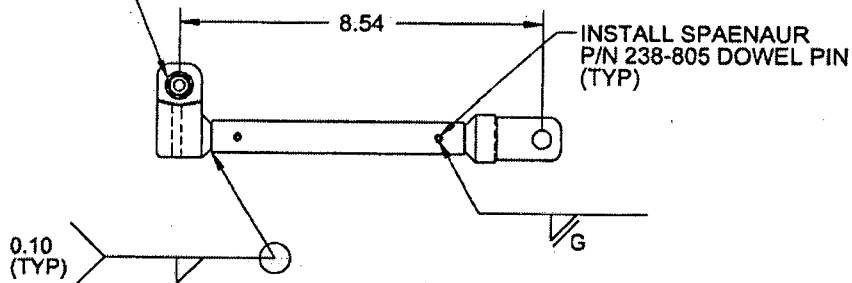
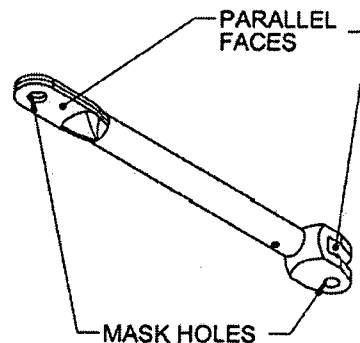
QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED05.12.09 *H*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D3443-043

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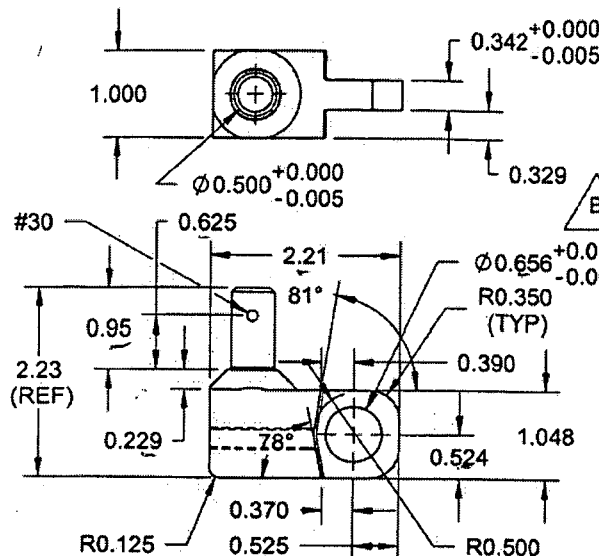
WORK ORDER
NO. *27794*

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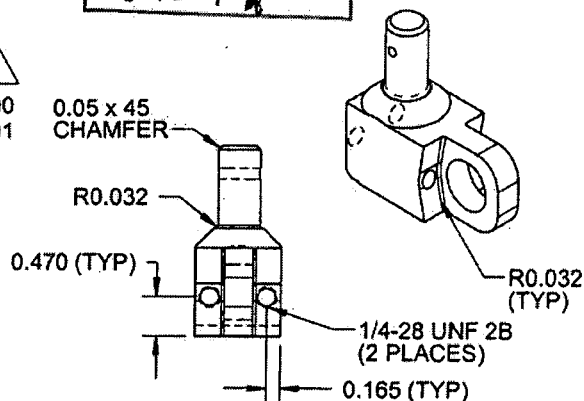
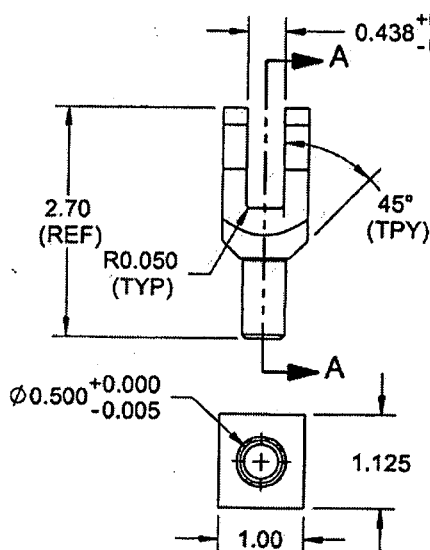
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 12		

**D3443-1 NOTES:**

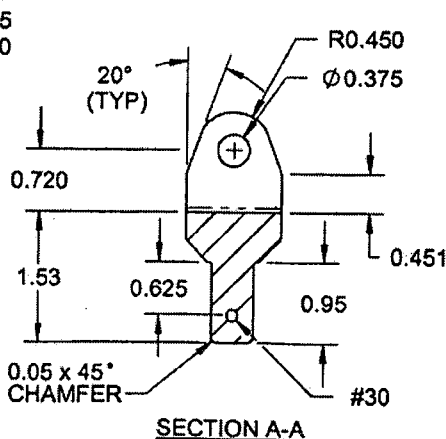
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

RELEASED05.12.04 *[Signature]***D3443-1 LUG****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

**D3443-3 CLEVIS**

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WORK ORDER

NO. 27794

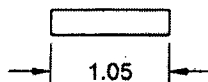
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

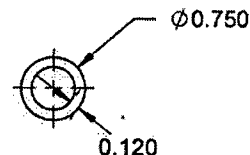
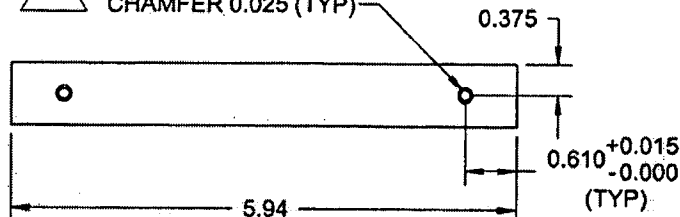
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.05

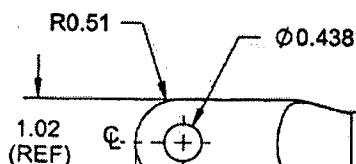
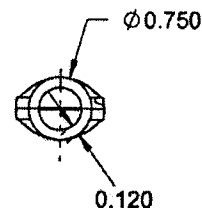
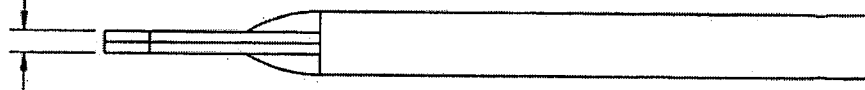


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

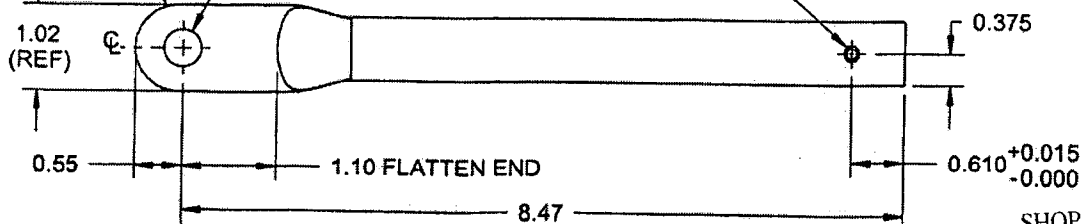


D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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WORK ORDER

NO. 27794

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DART AEROSPACE LTD		Work Order: 27794
Description: strut weldment assembly		Part Number: 03443-1
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000"	± .010"	1.003"	✓			
.342"	± .002"	.341"	✓			
.329"	± .010"	.334"	✓			
Ø .500"	± .005"	Ø .500"	✓			
2.21	± .030"	2.212"	✓			
Ø .656"	± .001"	Ø .656"	✓			
.625"	± .010"	.625"	✓			
.95	± .030"	.946"	✓			
2.230	± .030"	2.226"	✓			
.229	± .010"	.230"	✓			
.370"	± .010"	.373"	✓			
.525	± .010"	.524"	✓			
.524"	± .010"	.524"	✓			
.390"	± .010"	.391"	✓			
1.048"	± .010"	1.043"	✓			
.050 X 45°	± .030"	.050 X 45°	✓			
R0.032	± .010"	R0.032"	✓			
.470"	± .010"	.470"	✓			
.165"	± .010"	.165"	✓			
1/4-28 UNF		1/4-28	✓			

Measured by: J.F.	Audited by: En	Prototype Approval: N/A
Date: 06/07/03	Date: 06/07/03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	